



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D3506-1**Job Sheet 200913****Part No:** D3506-1**Job Qty:** 20 pcs**Part Name:** Doubler**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 9/19/19**Job Tracking No:****Due Date:** 10/7/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV A IPP Rev:A New Issue 06-05-31 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		10/7/19	0.17	0.60	Waterjet - Flow	9/30/19	JRB
110	QC 2	20 pcs		10/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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**Container No:** S218349**Part:** D3506-1**Job No:** 200913**Serial No/Batch:** S218349**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 09/30/19

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120 HAAS 4 Axis - B4B	20 pcs	10/7/19	0.05	1.58	HAAS - 1 - B4B	SRB 9/30/19 19-10-11
					HAAS - 2 - B4B	
					HAAS - 3 - B4B	
					HAAS - 4 - B4B	
130 QC 2	20 pcs	10/7/19	0.00	0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	SRB 19-10-11
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140 QC 8	20 pcs	10/7/19	0.00	0.00	QC 8 - 12	SRB 19/10/12
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	

					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
150 Small Fab - 2 - B4B	20 pcs	10/7/19	0.00 0.37	Small Fab - 1 - B4B		DAS 5 OCT 15 2019 Q.L.R.
				Small Fab - 2 - B4B		
				Small Fab - 3 - B4B		
				Small Fab - 4 - B4B		
				Small Fab - 5 - B4B		
				Small Fab - 6 - B4B		
				Small Fab - 7 - B4B		
				Small Fab - 8 - B4B		
160 QC 5	20 pcs	10/7/19	0.00 0.00	QC 5 - 10		DAS OCT 25 2019 40 9-80
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
170 Handfinish - 1-1 Chemical- B4B	20 pcs	10/7/19	0.00 0.35	Handfinish - 1 - 1 - B4B		BEB 19-10-25
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		

180 QC 7	20 pcs	10/7/19	0.00 0.00	Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
190 Packaging 3-1 - Stock - B4B	20 pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	

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9-89

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC 2601
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
200 QC 21 - SA	20 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DMS 21 OCT 28 2019
				QC 21 - SA - 53	8-58
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (HAAS CNC Vertical Machine) 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (QC8- Inspect parts - second check) 160 - (QC5- Inspect part completeness to step on W/O) 170 - (Chemical Conversion Coat per QSI005 4.1) 180 - (QC7-Inspect Chemical Conversion Coat) 190 - (Identify as per dwg & Stock Location: _____) 200 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6S.100	6061-T6 .100 Sheet	.1560 sf (.0078 ea)	100-Waterjet - Flow - 1	5025674	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M6061T6S.100	0	40	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order:	200913
Description: Doubler		Part Number:	D3506-1
Inspection Dwg: D3506 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.128	✓		DL.ohv	
Ø0.404	+0.006/-0.001	0.403	✓			
0.750	+/-0.010	0.751	✓			
1.500	+/-0.010	1.498	✓			
0.375	+/-0.010	0.374	✓			
0.750	+/-0.010	0.751	✓			
0.250	+/-0.010	0.250	✓			
0.098	+/-0.010	0.097	✓			
R1.772	±.010	1.772	✓		Rad gauge	

Measured by: JRB / SJ	Audited by: SJ	Prototype Approval:	N/A
Date: 9/30/19	Date: 19/10/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.09	New Issue	KJ/JLM	BE

Route update only

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